

Date: Tuesday, 4/18/2006 10:00:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 26662	
Estimate Number : 10706	
P.O. Number : N/A	Part Number : D2012103
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D2012 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : B2
Previous Run : 24983	Material : N/A
Written By : _____	Due Date : 5/7/2006 Qty: 5 Um: Each
Checked & Approved By : <u>KA 06.04.18</u>	
Comment : Est Rev: 02.04.03 Added Inspect level 3 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.5700 f(s)/Unit Total: 17.8500 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
 Identify as D2012-101
 Batch: M19488 x(4) / M100928 x(1) FF 06.05.10 5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-103 & template D2012-103T1(41.00")

FF 06.05.10 5

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2012-103 as per template D2012-103T2 & Dwg D2012-103

FF 06.05.10 5
MF 06.05.15 5
M.F. 06.05.13

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SBS 06/05/24 (5)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/05/01 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: [Signature] Date: 26/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26662

Part Number: D2012103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AL 06/06/01 (5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/06/01 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST206

AL 06/06/01 (5)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/02 (3)

Job Completion



u 06-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

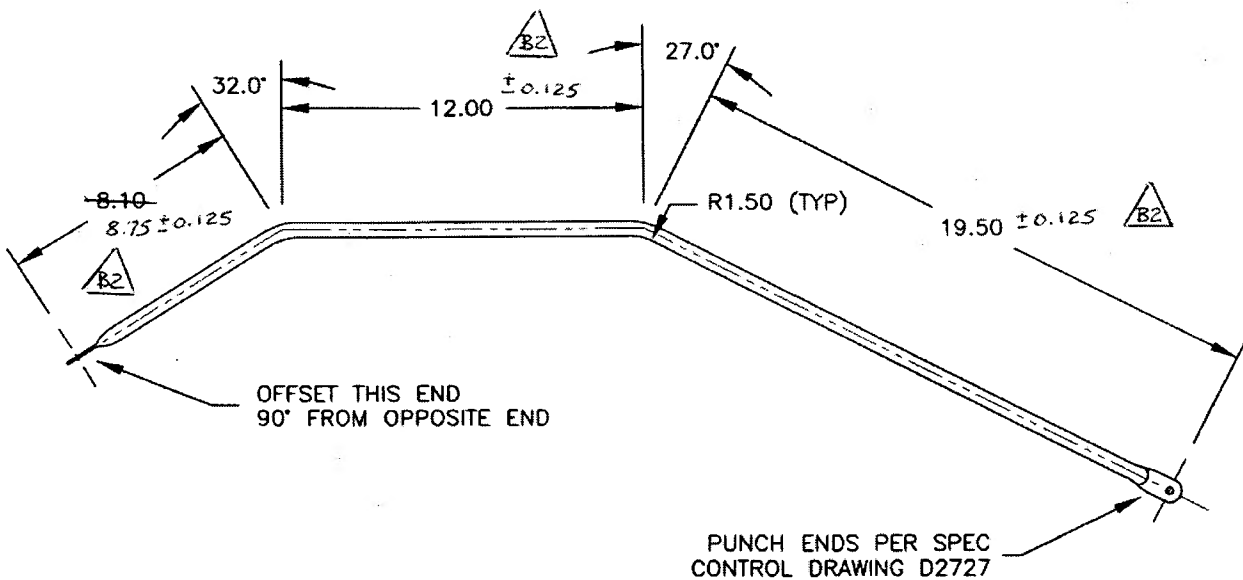
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
98/05/05 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
KE		KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MM	APPROVED	MM	DRAWING NO.	D2012-103
DATE	98.04.28	TITLE	ARM	REV. B	SHEET 1 OF 1
A	92.06.08	NEW ISSUE		SCALE	1:6
B	98.04.28	CHANGE ANGLES (TSR A362)			
B1	02.05.25	ADD FINISH			
B2	05.04.27	ADD TOLERANCE, 8.75 WAS 8.10			

**NOTES:**

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART 951045 4.3 **B1**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 26662